

Work Order ID 77685 -2

77685

Page 1

Friday, December 16, 2011 12:48:05 PM

Item ID: D3405-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug Assembly

Start Date: 12/16/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/6/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date: 1/12/16 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: PB

Prog Rev: PB

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

1311-12-29

1311-12-29

415

5 4/12/29

15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77685

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Page 2

Friday, December 16, 2011 12:48:05 PM

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 12/16/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/6/2012 Req'd Qty: 8.00 ***8*** Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Debur 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming	0.00 0.00				(14)	(40)		PTD
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(415)	(40)		Sr2lab09
150 *150* Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: <u>1118367</u> Large Fab Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-043	0.00 0.00							12-2-8 (18)

Dart Aerospace Ltd

W/O: 77685		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3405-043 PAR #: Fault Category: Small FAB / water jet NCR: Yes No DQA: ok Date: 12/2/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ok Date: 12/2/14

NCR: 12-1700		WORK ORDER NON-CONFORMANCE (NCR) 62.99						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/09	130	found 1 piece hole was not round at the water jet N.C. Axes	S 12/01/09 057042	Scrap & destroy no replace	S 12/01/09	S 12/01/09	S 12/01/09 057042	S 12/01/09

NOTE: Date & initial all entries

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Page 3

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Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly

Start Date: 12/16/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/6/2012 Req'd Qty: 8.00 ***8*** Customer:

Reference: Run Start ***NR1***
 Approvals: Process Plan: Date: Tooling: Date: Stop ***NR2***
 QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC9- Inspect visual per QSI004- Fusion Welds 0.00

160

QC

Quality Control

Memo

0.00

170 QC5- Inspect part completeness to step on W/O 0.00

170

QC

Quality Control

Memo

0.00

180 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

180

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

m 119480

3:00
4:00
3:30

Pl 12-02-08 8x Ø

S. 12/16/09

XB

8x4 m-f 12/12/09

Dart Aerospace Ltd

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 Start Date: 12/16/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/6/2012 Req'd Qty: 8.00 ***8*** Customer:

Reference: Run Start ***NR1***
 Approvals: Process Plan: Date: Tooling: Date: Stop ***NR2***
 QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: ST 478	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

8 BL 12-2-9

(8x) SP 12-02-10

12/02/13

12-02-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, December 16, 2011 12:48:09 PM

Page 1

Work Order ID: 77685

77685

Parent Item: D3405-043

D3405-043

Parent Item Name: Lug Assembly

Start Date: 12/16/2011

Required Date: 1/6/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A05.09.01 New issue KJ/JLM

IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1		Manufactured	No			100	Each	57.0000	1	8			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3404-1

GHW Lug

**

EL 12-2-8

Location

Loc Qty

Loc Code

WA030

57

70664

7

72326

5

74551

5

76994

40

M304S11GA

Purchased

No

150

sf

61.9000

0.154

1.296842

2.5

**

FB 11-12-09

M304S11GA

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

61.9

119006

32.5

119048

29.4

119006

15

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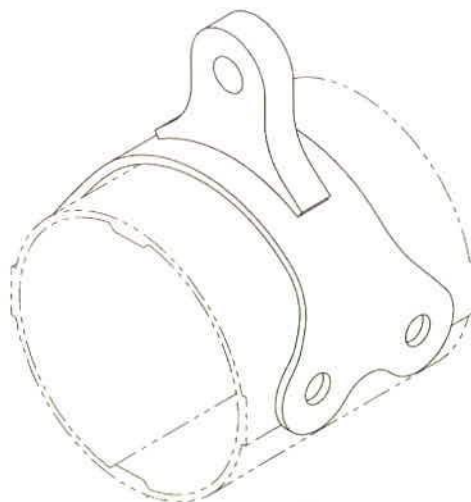
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

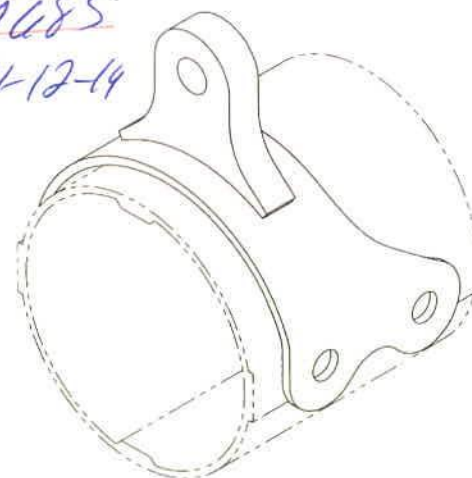
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77685
R11-12-14

RELEASED
08/12/18 MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198) SHEETS 3 & 4 ZONE A6 4 120 DIM WAS 4.100	AJS	08 09 19
A	NEW ISSUE	PH	05 03 08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG APPR.		D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AEROSPACE LTD.	

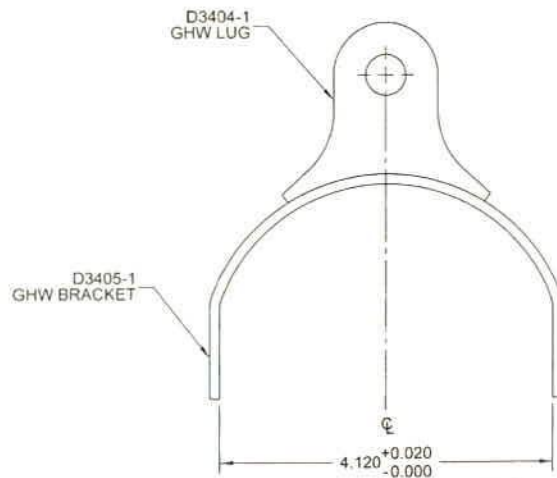
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

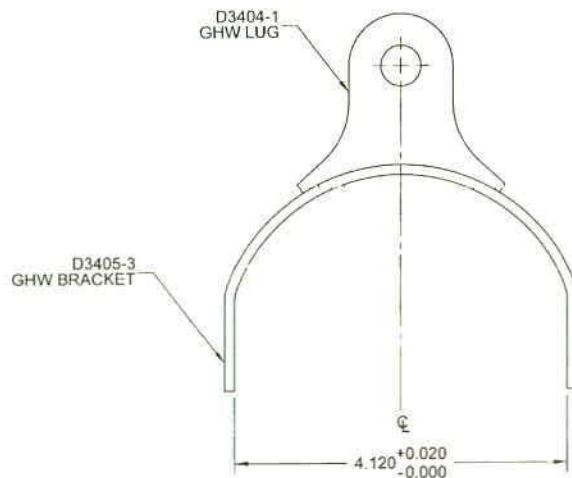
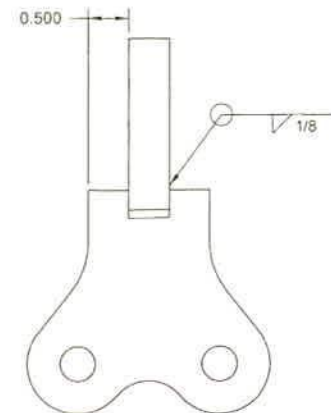
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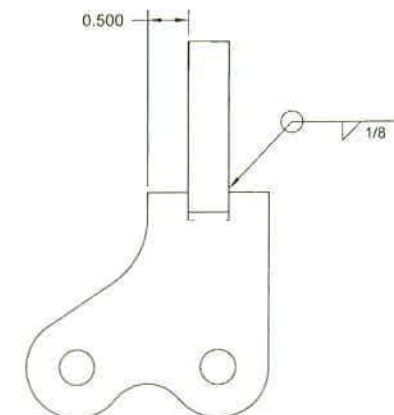
NOTE: Date & initial all entries



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



RELEASED
06/12/18 MJP

77685

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
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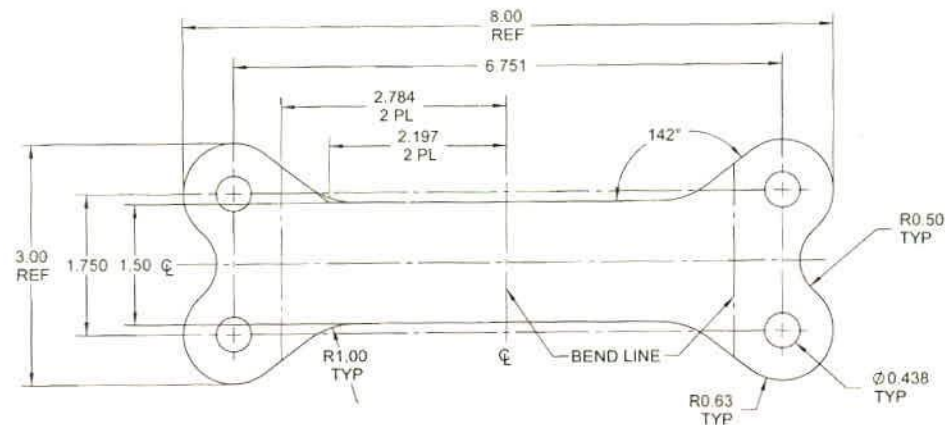
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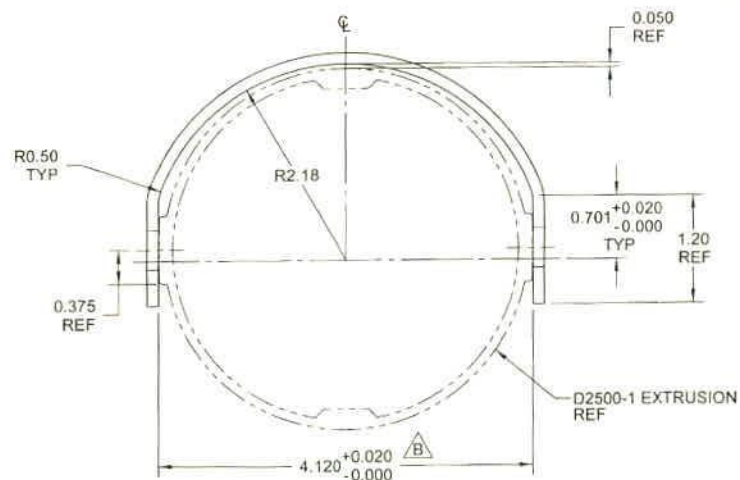
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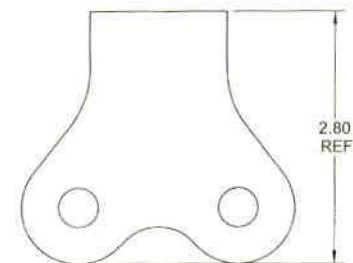
NOTE: Date & initial all entries



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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RELEASED
08/12/18

77685

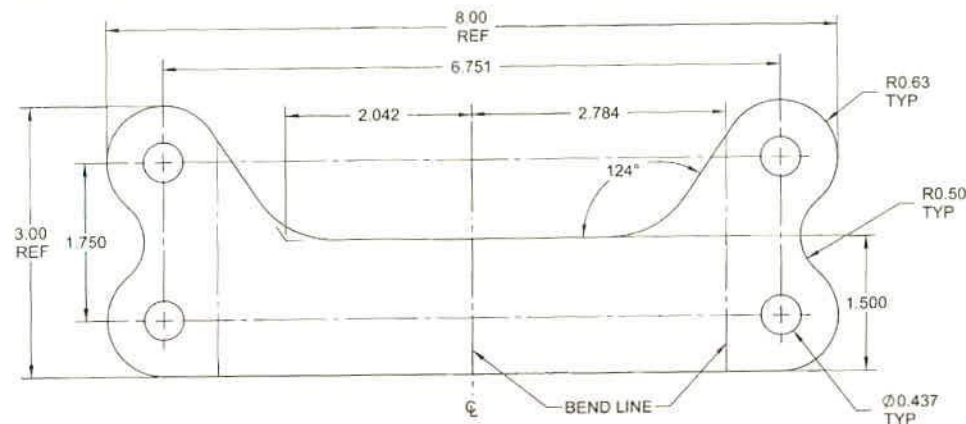
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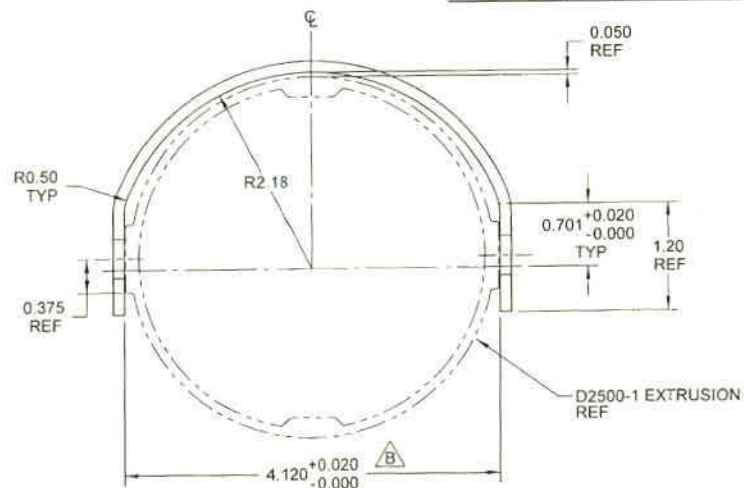
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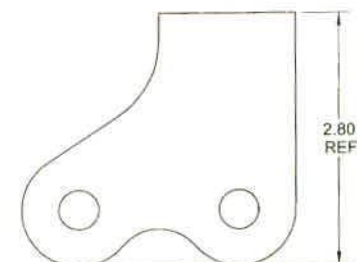
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D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

177685

RELEASED
06/12/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
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REF. DART SPEC. M304S11GA
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- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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CHECKED		DRAWING NO.	REV. B
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